

# Work Order ID 65882

Wednesday, January 26, 2011 1:53:56 PM



Page 1

Item ID: D4271-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam Assembly

Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 1/26/2011

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4271

~~AUR~~ Rev. B

BE 11/01/31

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Pick and Assemble as per dwg

*[Signature]*  
1/27/11  
1/2/11

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*[Signature]*  
1/2/11

*[Signature]*

120

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

*[Signature]*  
11/2/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65882**

Wednesday, January 26, 2011 1:53:56 PM

Page 2

Item ID: D4271-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Beam Assembly

Start Date: 1/26/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10 [Signature]

U 110210

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 26, 2011 1:54:03 PM

Page 1

Work Order ID: 65882

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly





Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D4149-5 Eyebolt Stud		Manufactured	No			100	Each	8.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ENG			1						
					64213		1						
				GA			7						
					61234		7						
 D4274-1 Plate, Fwd Support		Manufactured	No			100	Each	0.0000	2	2			
 D4275-1 Fwd Beam		Manufactured	No			100	Each	0.0000	1	1			
 D4281-1 Spacer		Manufactured	No			100	Each	2.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ENG			2						
					63886		2						

66 226

60790

①

65883

65676

63886

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 26, 2011 1:54:03 PM

Page 2

Work Order ID: 65882

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C12A

Purchased

No

100

Each

88.0000

8

8



Bolts

Location

Loc Qty

Loc Code

ST351

88

112314

8

114761

11

116022

2

116289

17

116428

50



*Handwritten signature*

MS20615-4M18

Purchased

No

100

Each

341.0000

8

8



Rivet

Location

Loc Qty

Loc Code

ST323

341

114808

152

115037

189



*116428*

*Handwritten signature*

MS21043-3

Purchased

No

100

Each

1,620.000

8

8



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1544

112314

1544



*114808*

*1/24/2011*

*112314*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, January 26, 2011 1:54:04 PM

Page 3

Work Order ID: 65882

Parent Item: D4271-011

Parent Item Name: Fwd Beam Assembly

Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

4,636.000

16

16



Washer

Location

Loc Qty

Loc Code

ST297

4636

115000

125

115698

35

116025

1476

116304

3000

116025

*6447*

*Ad 11.02.07  
perm. chg.*

AN4C13A

*(Qty 2)*

B# : *M116191*

*\**

*ES 11/02/10*

MS21043-4

*(Qty 2)*

B# : *M115936*

*\**

*ES 11/02/10*

NAS1149C0432R

*(Qty 4)*

B# : *M116805*

*\**

*ES 11/02/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

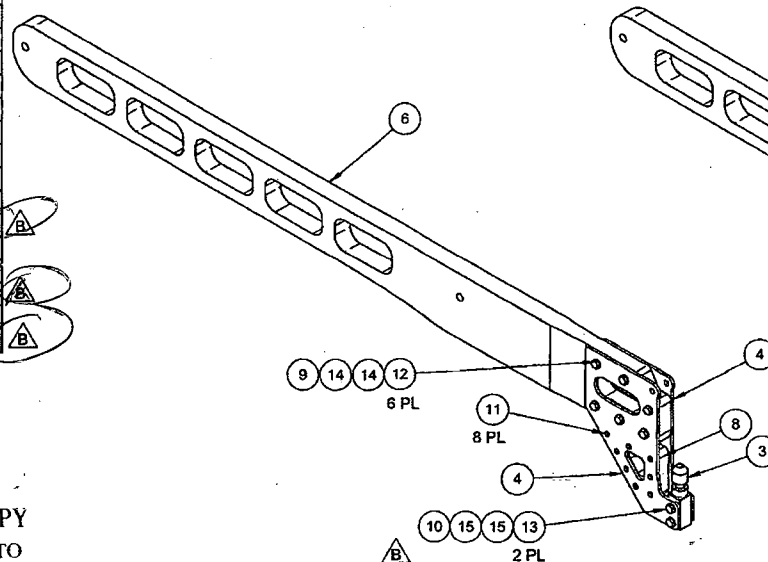
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

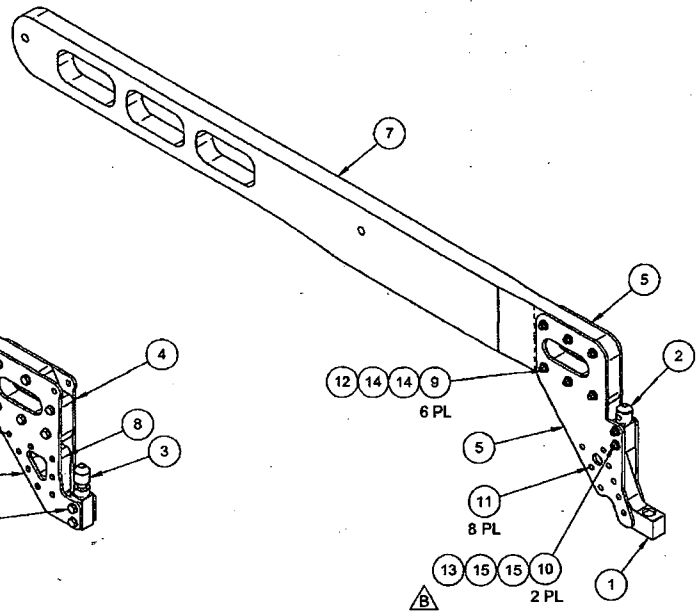
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -011	QTY -013	PART NUMBER	DESCRIPTION
			D4271-011	FWD BEAM ASSY
			D4271-013	AFT BEAM ASSY
1		1	D4148-3	STUD RECEIVER
2		1	D4148-5	EYEBOLT STUD
3	1		D4149-5	EYEBOLT STUD
4	2		D4274-1	PLATE, FWD SUPPORT
5		2	D4274-3	PLATE, AFT SUPPORT
6	1		D4275-1	FWD BEAM
7		1	D4276-1	AFT BEAM
8	1		D4281-1	SPACER
9	6	6	AN3C12A	BOLT
10	2	2	AN4C13A	BOLT
11	8	8	MS20615-4M18	RIVET
12	6	6	MS21043-3	NUT
13	2	2	MS21043-4	NUT
14	12	12	NAS1149C0332R	WASHER
15	4	4	NAS1149C0432R	WASHER



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45882

*2111-01-24*

**RELEASED**  
2010-12-06  
*WJD*

B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.01		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4271</b>	REV. B SHEET 1 OF 2
TITLE <b>SUPPORT BEAM ASSEMBLIES</b>	SCALE NTS
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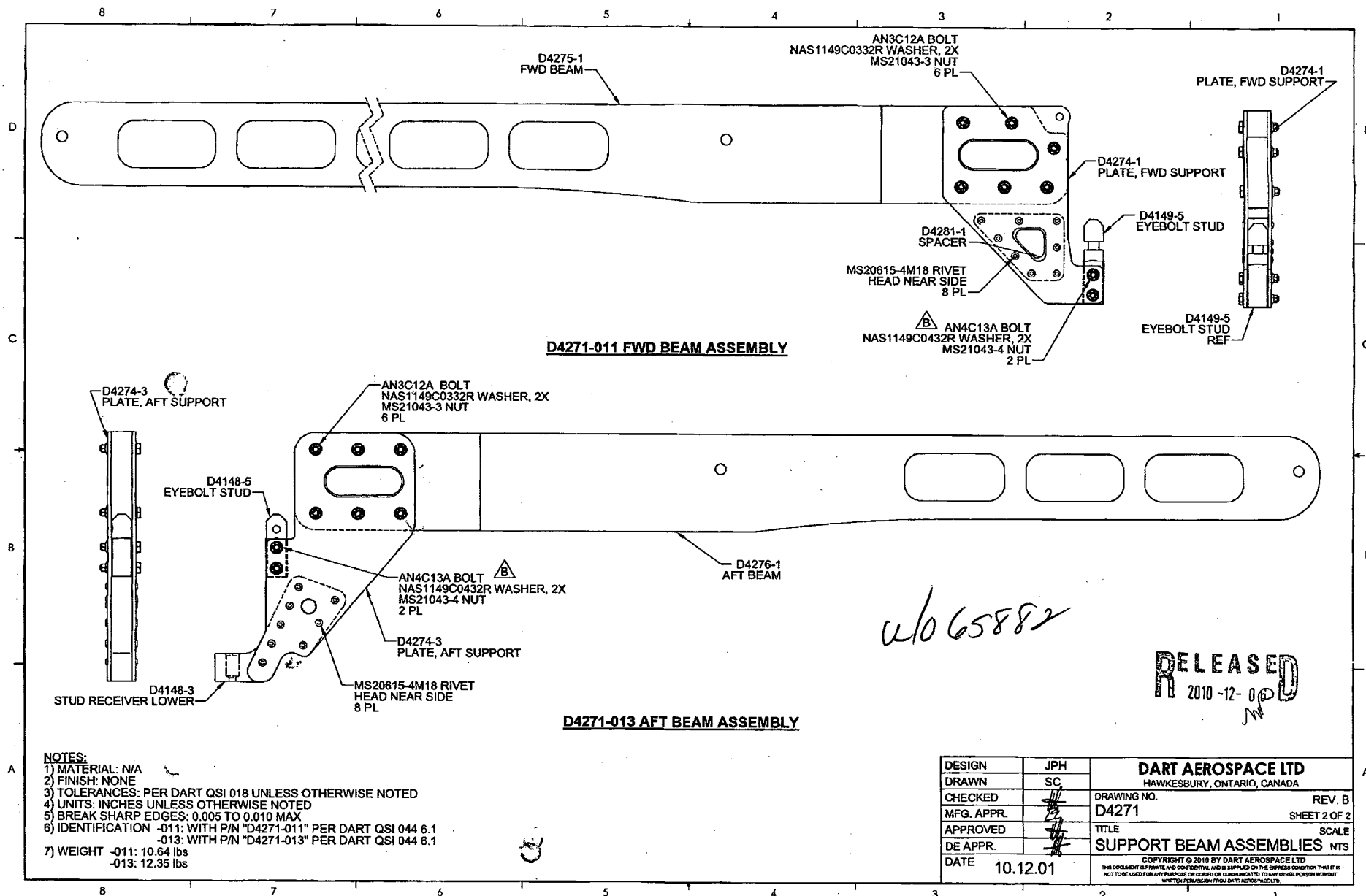
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**NOTE:** Date & initial all entries



DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4271</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>SUPPORT BEAM ASSEMBLIES</b>	NTS
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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